

Work Order ID 54514

December 10, 2009 2:35:09 PM



Page 1

Item ID: D105-674-011G

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube, Grey

Start Date: 10/12/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 23/12/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date: 09-12-10

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2966

Rev A2

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D105-674-011G CHG002

S10/01/05

09-12-10

110

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Determine square end of tube and deburr
2-Drill #30 pilot holes using DT8678. Open holes to Ø5/16" (0.313"). Deburr holes.

9-12-14

120

0.00



BENDING MACHINE - SKIDTUBES

CNC Bend 1

Memo

0.00

CNC Delta 100 Bender

Bend tube as per program BO105 on CNC Bender and Dwg D2966. Use 5/16" locator pin on buggy "A".

9-12-14

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Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

130

0.00



Skidtubes

Skidtubes

Memo

0.00

- 1-Cut Fwd end of the tube using DT8185-1
- 2-Cut Aft end at 107.06" using DT8185D
- 3-Debur ends
- 4-Drill Aft Cap holes using DT8678
- 5-Locate DT8679 with 1/8 clecos in Aft Cap holes. Ensure DT8679 is centered on Fwd end of tube and drill #40 Fwd bushing.
- 6-Clamp DT8679 to the tube. Drill all #30 wearplate and crossbdt holes.
- 7-Open Aft Cap holes using #6 drill
- 8-Open wearplate holes and two side holes to Ø19/64" (0.297") as per Dwg D2966-1.
- 9-Debur holes.
- 10-Open remaining (16) crossbolt holes to Ø0.500

140

0.00



Skidtubes

Skidtubes

Memo

0.00

- 1-Weld Fwd Cap as per Dwg D2966 and QSI 004. Fill #40 Fwd cleco hole.
- 2-Grind Fwd Cap welds flush

DP 9-12-16

BE 09/12/16
A/R M112860

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Cust Item ID:

Required Date: 23/12/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 27 8 09/12/16 0.00							
160 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 27 5 08/12/16 0.00							
170 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				1	11 9/12/16		

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Required Date: 23/12/2009 Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

180

QC3- Inspect Part Finish

0.00

9-12-16



QC

Memo

0.00

Quality Control

190

Skidtubes

0.00



Skidtubes

Memo

0.00

Skidtubes

1-Open crossbolt holes to finish size as per Dwg D2966
2-Open 14 holes to Ø0.750" & 2 holes to Ø0.875", countersink crossbolt holes &
remove alodine to prepare for welding as per Dwg D2966
3-Deburr holes inside & outside, blow out chips

1 9/12/16

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Item Name: Skidtube, Grey

Start Date: 10/12/2009 Start Qty: 1.00

Cust Item ID:

Required Date: 23/12/2009 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

200

0.00



Skidtubes

Skidtubes

Memo

0.00

1-Bond Web in place per QSI 015. (Ensure holes line up)

Pick:

QtyPart Numbe DescriptionBatch

A/RSikaflex-291 M112395

Sikaflex expiry date: 2010/02/30

2-Weld Crossbolt Spacers as per Dwg D2966 and QSI 004. For crossbolt spacer, wel

9-12-16
AWM 9-12-16
BE 09/12/17
A/R M112860

210

0.00



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

Memo

0.00

=> Solid 17



220

0.00



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

=> Solid 17



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Item ID: D105-674-011G

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Revision ID:

Stop



Item Name: Skidtube, Grey

Start Date: 10/12/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 23/12/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

230

Grey Sandtex(Ref:4.3.5.6) per QSI005.4.3

0.00 PRESSURE-WASH 09-12-18



Powdercoat

Memo

START TIME: 8:05

OVEN TEMPERATURE: 320°

FINISH TIME: 8:35

0.00

BR 09-12-21

(X)

Powder Coating

240

QC3- Inspect Part Finish

0.00

u 09-12-21



QC

Memo

0.00

(X)

Quality Control

250

HandFinishing

0.00



HandFinish

Memo

0.00

=> u 09-12-21

(X)

Hand Finishing

1-Inspect for foreign objects as per QSI 02

2-Install Inserts, Weaplate and Cap per Dwg D2966. Insert a drop of sikaflex at

insert holes before installing wearplates. Seal Aft Cap using Sikaflex. Install

bushing and nut. By looking Fwd, install nut t

10/12/20

3-Wing Walk Batch: M112623

BH sikaflex: M112391 exp: 2010/01

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Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube, Grey

Start Date: 10/12/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 25/12/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

260

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

md 09.12.29 ①

270

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

*****ENSURE INSERT ARE AT LOCATION (6) AS PER DWG
D2966*****

md 09.12.29 ①

280

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

9/12/29 ① SP

B54514

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Item ID: D105-674-011G

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube, Grey

Start Date: 10/12/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 23/12/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

290

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

28.10.105



Quality Control

300

Packaging

0.00



Packaging

Memo

0.00

Reva

Packaging

Identify and pack for shipping as per PPP D105-674-011G
Location: 02

10-1-5

310

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/01/06

mc 10-01-05

Picklist Print

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Page 1

Work Order ID: 54514

Parent Item: D105-674-011G

Parent Item Name: Skidtube, Grey



Start Date: 10/12/2009

Required Date: 23/12/2009



Comments:

Start Qty: 1.00





Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2962-125  Outer Tube Extrusion		Manufactured	No			110	Each	35.0000	1.0000 			

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	35	
17532	35	

D2964  Cap		Manufactured	No			140	Each	32.0000	1.0000 			
---	--	--------------	----	--	--	-----	------	---------	---	--	--	--

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	32	
14101	32	

D2976  BO 105 Skidtube I Beam		Manufactured	No			200	Each	0.0000	1.0000 			
D2971  Cross Bolt Spacer		Manufactured	No			200	Each	39.0000	1.0000 			

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	39	
44445	39	

① DP 9-12-14

1 BE 09/12/16
① DP 9-12-16

1 BE 09/12/17

Picklist Print

Page 2

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Work Order ID: 54514

Parent Item: D105-674-011G

Parent Item Name: Skidtube, Grey





Start Date: 10/12/2009

Required Date: 23/12/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2973  Cross Bolt Spacer		Manufactured	No			200	Each	213.0000	7.0000 			
				<u>Warehouse</u>	<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>			
				Main Warehouse	ST			213				
					14636			213				
D2965  Cap, 105 Skidtube		Manufactured	No			250	Each	59.0000	1.0000 			
				<u>Warehouse</u>	<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>			
				Main Warehouse	FP4			58				
					50924			2				
					52057			56				
				Main Warehouse	ST			1				
					43288			1				

7 BE 09/12/17

B54738 xl M 09-12-21

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Shop Packet Print

Page 2

Picklist Print

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Work Order ID: 54514

Parent Item: D105-674-011G

Parent Item Name: Skidtube, Grey

Start Date: 10/12/2009


Required Date: 23/12/2009

Comments:

Start Qty: 1.00


Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D2970-1		Manufactured	No			250	Each	25.0000	1.0000			
												
Wearplate												


Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	ST	25	
	(43726)	9	
	48213	16	

X1 09-12-21

D2970-3		Manufactured	No			250	Each	22.0000	1.0000			
												
Wearplate												

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	ST	22	
	(43727)	6	
	48214	16	

X1 09-12-21

D3176-1		Manufactured	No			250	Each	15.0000	1.0000			
												
Bushing												

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	ST	15	
	(37586)	15	

X1 09-12-21

Picklist Print

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Work Order ID: 54514

Parent Item: D105-674-011G

Parent Item Name: Skidtube, Grey



Comments:

Start Date: 10/12/2009

Required Date: 23/12/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3176-3		Manufactured	No			250	Each	25.0000	1.0000			
												
Nut												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	25	
37585	5	
44896	20	

X 1 M 09-12-21

ALS7-1032-130

Purchased

No

250

Each

2,330.000

36.0000

Insert

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	2330	
105855	16	
108606	52	
111529	938	
111779	313	
112772	11	
113238	1000	

X 36 M 09-12-21

Picklist Print

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Work Order ID: 54514



Parent Item: D105-674-011G



Parent Item Name: Skidtube, Grey

Start Date: 10/12/2009

Required Date: 23/12/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

MS27039-1-08		Purchased	No			250	Each	2,860.000	26.0000			
--------------	--	-----------	----	--	--	-----	------	-----------	---------	--	--	--



Screw

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
ST	2860	
110467	164	
110552	696	
110835	2000	

X36 09-12-21

AN960JD10L		Purchased	No			250	Each	5,433.000	28.0000			
------------	--	-----------	----	--	--	-----	------	-----------	---------	--	--	--



Washer

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
ST	5433	
101291	16	
104885	153	
105793	236	
109632	274	
110985	4754	

X 28 09-12-21

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Work Order ID: 54514

Parent Item: D105-674-011G

Parent Item Name: Skidtube, Grey

Start Date: 10/12/2009

Required Date: 23/12/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS27039-1-09		Purchased	No			250	Each	765.0000	2.0000			
Screw												

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	765	
107378	23	
111650	500	
18057	209	
8912	33	

09-12-21

D2972
Bushing

Manufactured	No	290	Each	123.0000	6.0000
--------------	----	-----	------	----------	--------

9/12/29 SP

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	123	
33544	92	
44160	31	

C

D2974
Packer

Manufactured	No	290	Each	11.0000	1.0000
--------------	----	-----	------	---------	--------

9/12/29 SP

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	11	
42715	11	

Picklist Print

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Parent Item Name: Skidtube, Grey

Start Date: 10/12/2009

Required Date: 23/12/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Rot # Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2975 Wearshoe		Manufactured	No			290	Each	17.0000	2.0000		9/12/09 SP	
-------------------	--	--------------	----	--	--	-----	------	---------	--------	--	------------	--

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	ST	17	
	41443	6	
	44894	11	

AN4-51A Bolt		Purchased	No			290	Each	362.0000	3.0000		9/12/09 SP	
-----------------	--	-----------	----	--	--	-----	------	----------	--------	--	------------	--

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	ST	362	
	111635	7	
	112489	5	
	112720	50	
	113121	100	
	113226	200	

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Parent Item Name: Skidtube, Grey

Comments:

Start Date: 10/12/2009

Required Date: 23/12/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN960JD10L

Purchased

No

290

Each

5,433.000

8.0000

Washer

9/12/09 SP

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

5433

101291

16

104885

153

105793

236

109632

274

110985

4754

MS21042L4

Purchased

No

290

Each

3,927.000

3.0000

Nut

9/12/07 SP (TV)

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

3927

110507

184

111827

3743

15924

0

Picklist Print

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Parent Item: D105-674-011G



Parent Item Name: Skidtube, Grey

Start Date: 10/12/2009

Required Date: 23/12/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg# Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS27039-1-08 Screw		Purchased	No			290	Each	2,860.000	8.0000			

9/12/29 *sp*

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

2860

110467

164

110552

696

110835

2000

8



DESIGN RF	DRAWN BY RF	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2966	REV. A SHEET 1 OF 2
DATE 00.03.08		TITLE BO 105 SKIDTUBE ASSEMBLY	SCALE NTS
A	00.03.08	NEW ISSUE	

RELEASED
00.05.11 #

Qty	Part Number	Description
X	D2966-041	SKIDTUBE ASSEMBLY
1	D2962-125	EXTRUSION
1	D2964	CAP
1	D2965	CAP
1	D2970-1	WEARPLATE
1	D2970-3	WEARPLATE
1	D2971	CROSS BOLT SPACER
7	D2973	CROSS BOLT SPACER
1	D2976	WEB
36	ALS7-1032-130 or ALS4-1032-130 or AKS7-1032-130 or AKS4-1032-130	INSERT
28	AN960JD10L	WASHER
26	MS27039-1-08	SCREW
2	MS27039-1-09	SCREW
1	D3176-1	BUSHING
1	D3176-3	NUT



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 54514
PL 09-12-10

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) WELDING TO BE DONE PER DART QSI 004.
- 3) INSERT D2976 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015 AFTER BENDING.
- 4) USE DART DRILL TEMPLATE DT8451 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION B-B (34 PLACES) AFTER FINISH. SEAL WEARPLATE SCREWS WITH SIKAFLEX-241/-291.
- 5) DO NOT INSTALL MS27039-1-08 SCREWS AND AN960JD10L WASHERS IN THESE LOCATIONS.
- 6) INSTALL ALS7-1032-130 INSERT, MS27039-1-08 SCREW, AND AN960JD10L WASHER IN 2 PLACES THIS LOCATION BEFORE POWDER COATING.
- 7) FINISH:
ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2976 WEB
POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTER LINE PER DART QSI 005 4.4 (OPTIONAL) BLACK SANDTEX (REF 4.3.5.7)

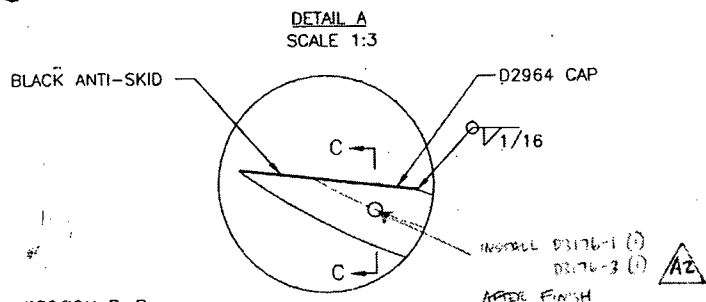


01.01.29
CP 01.01.30

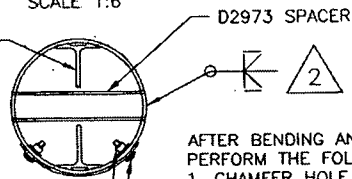
A2	02.10.30	ADD D3176-1/-3	# UP
A1	01.01.29	CHANGE COLOR TO BLACK SANDTEX	# UP

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SECTION B-B
SCALE 1:6



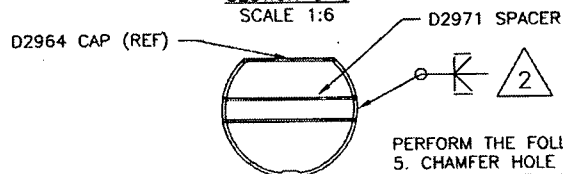
AFTER BENDING AND DRILLING ASSEMBLY
PERFORM THE FOLLOWING FOR $\phi 0.750$ HOLES ONLY:

1. CHAMFER HOLE $0.030 \times 45^\circ$
2. INSERT D2973 SPACER (7 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. PASS $\phi 0.630$ DRILL TO REMOVE SPILL OVER

1032-130 INSERT (34 PLACES)

MS27039-1-08 SCREW (1)
AN960JD10L WASHER (1)
(26 PLACES)

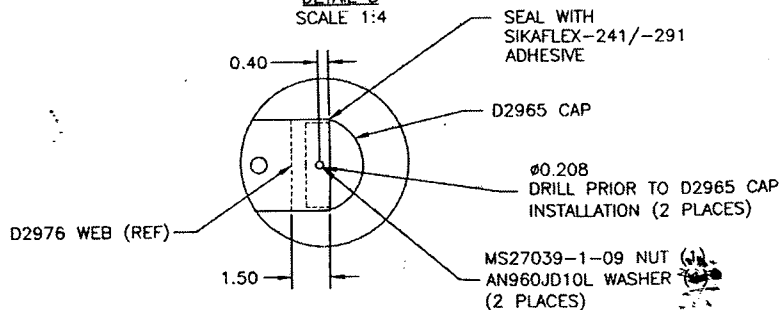
SECTION C-C
SCALE 1:6



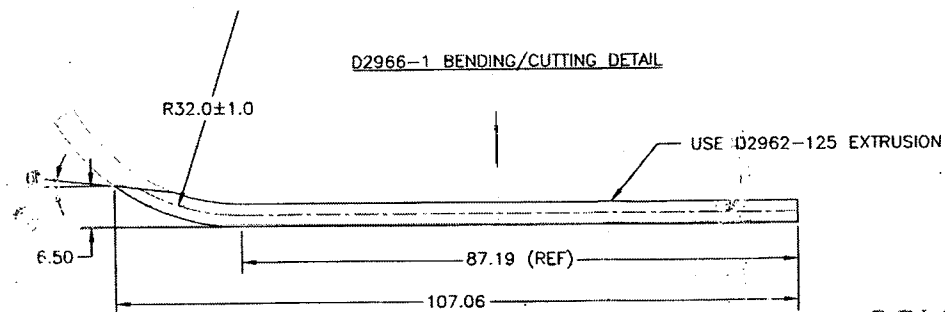
PERFORM THE FOLLOWING FOR $\phi 0.625$ HOLES ONLY:

5. CHAMFER HOLE $0.030 \times 45^\circ$
6. INSERT D2971 SPACER
7. WELD INTO PLACE AND GRIND FLUSH
8. PASS $\phi 0.484$ DRILL TO REMOVE SPILL OVER

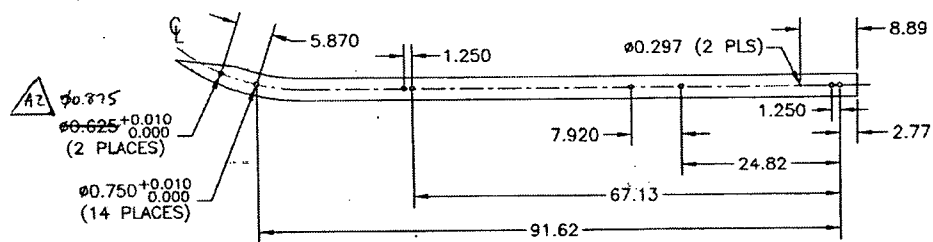
DETAIL D
SCALE 1:4



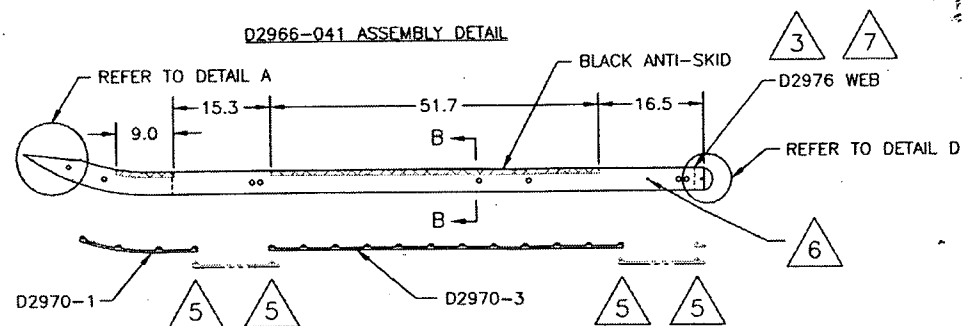
D2966-1 BENDING/CUTTING DETAIL



D2966-1 DRILLING DETAIL



D2966-041 ASSEMBLY DETAIL



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DESIGN
RF
CHECKED

DATE
00.03.08

DRAWN BY
RF
APPROVED
#

DART DART AEROSPACE USA, INC.
BELLEVUE, WA
DRAWING NO.
D2966
TITLE
BO 105 SKIDTUBE ASSEMBLY
REV. A
SHEET 2 OF 2
SCALE
1:20

RELEASED
00-05-11

W/D 541514

NO. 192

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Bardley Elliot
Job number: 44849
Part number: D105 674 Oil WC
Description: 60 105
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual:
Penetration:

pass[☒] fail[]
pass[☒] fail[]

UNACCEPTABLE

Cracks:
Undercut:
Pin holes:
Overlap (cold lap)
Porosity (surface):
Coloration:

pass[☒] fail[]
pass[☒] fail[]
pass[☒] fail[]
pass[☒] fail[]
pass[☒] fail[]
pass[☒] fail[]

Qualifier Pet Duvel

Date of Test Coupon 09.02.05

Welder Bardley Elliot

Date of Test Coupon 09.02.05

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

